

Work Order ID 135138

Thursday, July 30, 2015 8:10:50 AM

135138

Page 1

Item ID: K10004

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heavy Duty Saddle

Start Date: 7/30/2015 Start Qty: 3.00 ***3***

Cust Item ID:

Required Date: 8/7/2015 Req'd Qty: 3.00 ***3***

Customer:

Reference:

Approvals: Process Plan: mf Date: 15-7-30 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC(Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
K10004	Rev E								SH 15-07-31
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile for K10004, D205-594-011/-013/-015 & D412-652-011/-21 and type labels per PPP K10004 CHG005								
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.00							
Quality Control									

X3 **MAS**
27
9-89
APR 08 20163x **SP** 15-07-31
SPX3 **MAS**
27
9-89
APR 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

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Revision ID:

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Cust Item ID:

Required Date: 8/7/2015 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Identify as per dwg & Stock Location: _____

0.00

120

Packaging

Memo

0.00

Packaging

Location : FG129

3X

BAS

27

9-89

APR 08 2016

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MWS

APR 11 2016

MWS APR 11 2016

DQA: _____ Date: _____



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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐			
Misidentified ☐	Past Due ☐				

Picklist Print

Thursday, July 30, 2015 8:10:48 AM

Page 1

Work Order ID: 135138

135138

Parent Item: K10004

K10004

Parent Item Name: Heavy Duty Saddle

Start Date: 7/30/2015

Required Date: 8/7/2015

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP : D05.07.22Reformat; Added D3428-3 per CHG003KJ/JLM
 IPP Rev:E 08-09-29 revD as per dwg DD verified by: IPP Rev:F
 chg005 DD 10.06.03 verf:JLM IPP REV:G 13.08.21
 REMOVED D3428-3 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN4-51A		Purchased	No			105	Each	214.0000	16	48			DAS 26 9-89
Bolt													

Location	Loc Qty	Loc Code
FG	5	
122993	5	
ST312A	209	
m131624	9	
m132344	50	
m132536	75	
m132551	75	

AN5-15A		Purchased	No			105	Each	60.0000	32	96			DAS 26 9-89
Bolt													

Location	Loc Qty	Loc Code
GA	60	
m130095	60	

AN5-36A		Purchased	No			105	Each	55.0000	2	6			DAS 26 9-89
Bolt													

Location	Loc Qty	Loc Code
ST299A	40	
M131957	1	
M132551	39	
ST336	15	
M130466	15	

JUL 30 2015

DQA: _____ Date: _____



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Picklist Print

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Page 2

Work Order ID: 135138

135138

Parent Item: K10004

K10004

Parent Item Name: Heavy Duty Saddle

Start Date: 7/30/2015

Required Date: 8/7/2015

Start Qty: 3.00

Required Qty: 3.00

AN5-42A	Purchased	No	105	Each	8.0000	2	6		DAS 26 9-89
AN5-42A									

Bolt									
DAS 27 9-89									
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
		ST336	8						
		m127475	8						

AN5-43A	Purchased	No	105	Each	11.0000	2	6		DAS 26 9-89
AN5-43A									

Bolt									
DAS 27 9-89									
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
		ST336	11						
		112243	1						
		M127933	2						
		M128028	8						

AN5-45A	Purchased	No	105	Each	22.0000	2	6		DAS 26 9-89
AN5-45A									

Bolt									
DAS 27 9-89									
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
		ST335	22						
		M127933	22						

D205-641-011	Manufactured	No	105	Each	0.0000	2	6		DAS 26 9-89
D205-641-011									

Ground Handling Lugs									

130975x3
135483x3

JUL 30 2015

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Shop Packet Print

Page 2

DQA: _____ Date: _____



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Outside Dimensions ☐																																																																						
Over/Under tolerance ☐																																																																						
Part Incorrect ☐																																																																						
Part Lost/Missing ☐																																																																						
Part Moved ☐																																																																						
Drawing ☐																																																																						
Finish ☐																																																																						
Misread ☐																																																																						
Turning Sequence ☐																																																																						
OTHER : ☐																																																																						

Picklist Print

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Page 3

Work Order ID: 135138

135138

Parent Item: K10004

K10004

Parent Item Name: Heavy Duty Saddle

Start Date: 7/30/2015

Required Date: 8/7/2015

Start Qty: 3.00

Required Qty: 3.00

D2570 Manufactured No

105 Each 391.0000 32 96

D2570

Bushing

DAS
27
9-89

Location	Loc Qty	Loc Code
FG	12	
88781	12	
FP001	131	
133432	131	
ST008	210	
116925	4	
134382	206	
ST012a	38	
129830	2	
132548	36	

96x

DAS
26
9-89

D3407-041

Manufactured No

105 Each 10.0000 2

D3407-041

Tow Ring

DAS
27
9-89

Location	Loc Qty	Loc Code
st530	10	
107840	3	
119184	2	
133789	5	

6
133096x1

DAS
26
9-89

D3417-5

Manufactured No

105 Each 79.0000 4 12

D3417-5

Washer

DAS
27
9-89

Location	Loc Qty	Loc Code
ST038A	79	
131054	39	
133476	40	

12x

DAS
26
9-89

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Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

Picklist Print

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Page 4

Work Order ID: 135138

135138

Parent Item: K10004

K10004

Parent Item Name: Heavy Duty Saddle

Start Date: 7/30/2015

Required Date: 8/7/2015

Start Qty: 3.00

Required Qty: 3.00

D3456-1
D3456-1
Washer

Manufactured No

105 Each 114.0000 2 6

**

DAS
26
9-89

Location Loc Qty Loc Code

FG	7	
25701	7	
ST038	4	
130974	4	
ST038A	100	
134407	100	
ST051A	3	
128456	3	

DAS
27
9-89

D5951
D5951
Saddle
D5953
9-89

Manufactured No

105 Each 0.0000 2 6

**

DAS
26
9-89
MAR 15 2016

Manufactured No

105 Each 4.0000 2 6

**

DAS
26
9-89

Location Loc Qty Loc Code

ST398	4	
127303	4	

DAS
27
9-89

D5955
D5955
Saddle

Manufactured No

105 Each 5.0000 2 6

**

DAS
26
9-89
JUL 30 2015

Location Loc Qty Loc Code

ST399	5	
124142	1	
127341	4	

DAS
27
9-89

B131703

DAS
26
9-89

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Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																	
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																	
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				QC / QA Coordinator Approval																																																																
Root Cause <table style="width:100%; border: none;"> <tr><td style="border: none;">Environment ☐</td><td style="border: none;">No Re-verification ☐</td></tr> <tr><td style="border: none;">Design ☐</td><td style="border: none;">Operator ☐</td></tr> <tr><td style="border: none;">Doc/Data ☐</td><td style="border: none;">Offset/Setup ☐</td></tr> <tr><td style="border: none;">Equip/Tooling ☐</td><td style="border: none;">Supplier ☐</td></tr> <tr><td style="border: none;">Handling/Pre ☐</td><td style="border: none;">Training ☐</td></tr> <tr><td style="border: none;">Material ☐</td><td style="border: none;">Use for Testing ☐</td></tr> <tr><td style="border: none;">Internal Transport ☐</td><td style="border: none;">Poor Information ☐</td></tr> <tr><td style="border: none;">Tribal Knowledge ☐</td><td style="border: none;">Rushing ☐</td></tr> <tr><td style="border: none;">LOA ☐</td><td style="border: none;">Product Improvement ☐</td></tr> <tr><td style="border: none;">Substation ☐</td><td style="border: none;">Process Improvement ☐</td></tr> <tr><td style="border: none;">Past Expiry Date ☐</td><td style="border: none;">Manufacturing Process ☐</td></tr> <tr><td style="border: none;">Misidentified ☐</td><td style="border: none;">Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%; border: none;"> <tr><td style="border: none;">Pressure/Forced ☐</td><td style="border: none;">Temperature/Cure ☐</td><td style="border: none;">Power Loss/Surge ☐</td><td style="border: none;">Positioned Wrong ☐</td></tr> <tr><td style="border: none;">Bending ☐</td><td style="border: none;">Set-up ☐</td><td style="border: none;">Folio/Program ☐</td><td style="border: none;">Outside Dimensions ☐</td></tr> <tr><td style="border: none;">Centre Not Concentric ☐</td><td style="border: none;">BOM/Route ☐</td><td style="border: none;">Grain ☐</td><td style="border: none;">Over/Under tolerance ☐</td></tr> <tr><td style="border: none;">Cracks ☐</td><td style="border: none;">Broken/Damage/Defect ☐</td><td style="border: none;">Weld ☐</td><td style="border: none;">Part Incorrect ☐</td></tr> <tr><td style="border: none;">Crimp/Kink/Ripple/Wave ☐</td><td style="border: none;">Inspection Incomplete/Unqualified ☐</td><td style="border: none;">Wrong Stock Pulled ☐</td><td style="border: none;">Part Lost/Missing ☐</td></tr> <tr><td style="border: none;">Cuffs ☐</td><td style="border: none;">Contamination ☐</td><td style="border: none;">Out of Sequence ☐</td><td style="border: none;">Part Moved ☐</td></tr> <tr><td style="border: none;">Crushing ☐</td><td style="border: none;">Countersink ☐</td><td style="border: none;">Off-set ☐</td><td style="border: none;">Drawing ☐</td></tr> <tr><td style="border: none;">Heat Treat ☐</td><td style="border: none;">Cut Too Short ☐</td><td style="border: none;">Mislabeled ☐</td><td style="border: none;">Finish ☐</td></tr> <tr><td style="border: none;">Wave/Twist in Tube ☐</td><td style="border: none;">Instructions Incomplete/Unclear ☐</td><td style="border: none;">Fit/Function ☐</td><td style="border: none;">Misread ☐</td></tr> <tr><td style="border: none;">Marks/Chatter ☐</td><td style="border: none;">Drill Holes ☐</td><td style="border: none;">Misaligned/off center ☐</td><td style="border: none;">Turning Sequence ☐</td></tr> </table>			Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Environment ☐	No Re-verification ☐																																																																			
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Tribal Knowledge ☐	Rushing ☐																																																																			
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Substation ☐	Process Improvement ☐																																																																			
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Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																	
Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																	
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OTHER :																																																																				

Picklist Print

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Page 5

Work Order ID: 135138

135138

Parent Item: K10004

K10004

Parent Item Name: Heavy Duty Saddle

Start Date: 7/30/2015

Required Date: 8/7/2015

Start Qty: 3.00

Required Qty: 3.00

D5957

Manufactured No

105

Each

3.0000

2

6

DAS

DAS
26
9-89

D5957

Saddle

DAS
27
9-89

Location

Loc Qty

Loc Code

ST399

3

B31964

3

119028

1

130251

2

Lx
2x

✓ SP

MS21042L4

Purchased

No

105

Each

3,299.000

16

48

DAS

DAS
26
9-89

MS21042L4

Locknut

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

142

m127813

142

ST260a

170

m130799

56

m131803

6

m132262

108

ST305

2985

m128300

8

m128798

12

m130388

7

m130922

97

m131618

12

m132123

56

m132382

2793

48x

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			

Root Cause	FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐

Picklist Print

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Page 6

Work Order ID: 135138

Parent Item: K10004

Parent Item Name: Heavy Duty Saddle

135138

K10004

Start Date: 7/30/2015

Required Date: 8/7/2015

Start Qty: 3.00

Required Qty: 3.00

MS21042L5

Purchased

No

105

Each

740.0000

40

120

MS21042L5

Nut

Location

Loc Qty

Loc Code

GA

146

m127813

146

ST260a

500

m132677

500

ST305

94

m127813

19

m131340

21

m132123

8

m132256

46

MS21043-4

Purchased

No

105

Each

851.0000

2

6

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

202

m128798

202

ST273A

300

m132803

300

ST304

309

m128818

39

m131697

9

m132382

4

m132536

257

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			

Root Cause	FAULT CATEGORY		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐			

Picklist Print

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Page 7

Work Order ID: 135138

135138

Parent Item: K10004

K10004

Parent Item Name: Heavy Duty Saddle

Start Date: 7/30/2015

Required Date: 8/7/2015

Start Qty: 3.00

Required Qty: 3.00

NAS1149D0563J

Purchased

No

105

Each

1,495.000

80

240

NAS1149D0563.I

Washer

DAS
26
9-89

JUL 31 2015

b

DAS
27
9-89

Location

Loc Qty

Loc Code

GA	53	
m125807	53	
ST260a	1267	
m130799	63	
m132035	55	
m132256	549	
m132677	600	
ST269	156	
m128257	156	
ST271	19	
m131026	19	

240x

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING LANDING GEAR INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 412	D412-652-011 D412-652-021
BELL 205/212/214	D205-594-011 D205-594-013 D205-594-015
BELL 204	D205-594-021 D205-594-023

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10004	D412-652-011 D412-652-021	D205-594-011 D205-594-013 D205-594-015 D205-594-021 D205-594-023
D205-641-011	2	2	2
D2570	32	32	32
D3407-041	2	2	2
D3417-5	4	4	4
D3428-3*	1	N/A	1
D3456-1	2	2	2
D5951	2	2	2
D5953	2	2	2
D5955	2	2	2
D5957	2	2	2
AN4-51A	16	16	16
AN5-15A	32	32	32
AN5-36A	2	2	2
AN5-42A	2	2	2
AN5-43A	2	2	2
AN5-45A	2	2	2
AN960JD516	80	80	80
MS21042-4 (OR L4)	16	16	16
MS21042-5 (OR L5)	40	40	40
MS21043-4	2	2	2

*REQUIRED WITH D205-594-011/-013 INSTALLATIONS ON 214 AIRCRAFT ONLY

E	D3407-041 WAS D3407-045; REMOVE D3812-1; REASON: TOW RING IS CHANGED ON D205-634-011/ D204-635-011 SKIDTUBES @ CHG 007 AND D205-634-015 SKIDTUBES @ CHG 006. SEE DSI 9417/9418 @ REV. B	PH	09.01.28
D	D3407-041 WAS D2707-041; D3456-1 WAS AN970-4; MS21043-4 REPLACES MS21042-4 (QTY 2); ADD D3417-5 AND D3812-1; ADD REFERENCE TO D205-594-021/-023	PH	08.09.11
C	ADD D3428-3 PLACARD	PH	05.07.22
B	ADD D2707-041 OPTION	DS	00.11.22
A	NEW ISSUE	DS	00.06.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		K10004	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SADDLE KIT	NTS
DATE	09.01.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	